



Dart Aerospace Ltd.
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D3903-1
Job Sheet 181689



Part No: D3903-1

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/4/18

Job Tracking No:

Due Date: 8/24/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	8/24/18	8/24/18	0.00	0.00	Start Up Machining-2		✓ JBD 8/10/18
100	Hardinge	60 pcs	8/24/18	8/24/18	0.00	1.62	Hardinge		↓
110	QC	60 pcs	8/24/18	8/24/18	0.00	0.00	QC2 Machining-2		↓
120	QC	60 pcs	8/24/18	8/24/18	0.00	0.00	QC8 Machining-2		
125	Skidtubes	60 pcs	8/24/18	8/24/18	0.00	0.39	Skidtubes-2		BE
130	Packaging	60 pcs	8/24/18	8/24/18	0.00	0.00	Packaging3-2		BE
140	QC21-SA	60 Ea	8/24/18	8/24/18	0.00	0.00	QC21		OCT 09 2018

Part Op 100 - 1-TURN AS PER FOLIO FA813 & DWG D3903,
Descriptions: 125 - Clean spacers with Ultra Aluminum Cleaner
130 - LOCATION : LG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.375W.058	6061-T6 Round Tube .375 X.058W	20.7000 ft (.345 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.375W.058	21	178	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.375Inches + 0.006 - 0.001	0.381 0.374	Diameter	
2	Spacer	0.259Inches + 0.006 - 0.001	0.265 0.258	Diameter	
3	Spacer	4.080Inches ± 0.030	4.110 4.050		
4	Spacer	0.030Inches ± 0.010	0.040 0.020		
5	Spacer	45.000Degrees ± 0.500	45.500 44.500	angle	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____		Step # _____		1270 Aberdeen Street Windsor, ON K6A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S116459 Part: D3903-1 Job No: 181689 Serial No/Batch: S116459 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/07/18						
Description Work Order		MRB (QSI042) Approval								
		Completed By								
		Lead hand / Supervisor Approval Verification								
		QC / QA Coordinator Approval		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence						
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; border-right: 1px solid black;"> Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; border-right: 1px solid black;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>				Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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